

Work Order ID 58897

May 20, 2010 10:49:25 AM



Page 1

Item ID: D412-761-049

Accept



Setup Start



Revision ID:

Stop



Item Name: Armrest

Start Date: 5/19/10

Start Qty: 3.00



Cust Item ID:

Required Date: 5/28/10

Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-761

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-761-049 CHG002

N/A

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

PULL FROM STOCK:
3 X D412-761-049
B54796, B56679, B57756

25 10/05/31

111

0.00



Small Fab

Memo

0.00

Small Fab

DISASSEMBLE 6 X D3780-041 B56891
KEEP PARTS TO REASSEMBLE

BRING D3696-041 TO MANUAL MILL

N/A

*all have
holes per Rev D.*

10-03

Work Order ID 58897

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Page 2

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

112

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

DRILL/COUNTERSINK PER DRWG D3696 REV.D, PER ECN 10-573

113

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

114

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

N/A

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115



Small Fab

Small Fab

Memo

RE-ASSEMBLE PER DRWG D3780

0.00

0.00

116



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

u

N/A

Work Order ID 58897

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Page 4

Item ID: D412-761-049

Accept



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Item Name: Armrest

Start Date: 5/19/10

Start Qty: 3.00



Cust Item ID:

Required Date: 5/28/10

Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

RE-PACKAGE PER PPR
USING NEW B/N

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

RESTOCKED UNDER ORIGINAL B/N
NO CHNG READ

10/06/04

10-06-03

Picklist Print

May 20, 2010 10:49:25 AM

Page 1

Work Order ID: 58897



Parent Item: D412-761-049



Parent Item Name: Armrest

Start Date: 5/19/10

Required Date: 5/28/10

Comments: I/P Rev:A 08-09-10 new issue DD verified by:JLM
I/P Rev:B 09-01-13 rev.C as per dwg DD verified by:EC

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D412-761-049

Manufactured

No

Each

3.0000



Armrest

Location

Loc Qty

Loc Code

FG031A

3

54796

1

56679

1

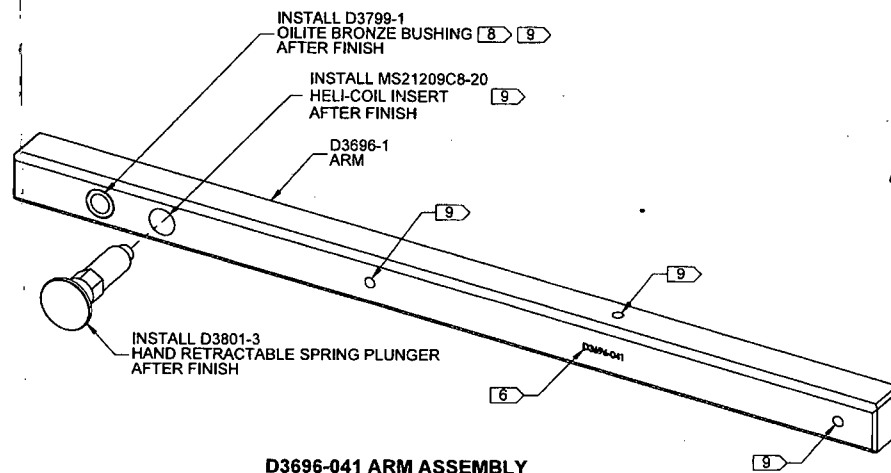
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N/A

W

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3696-041	ARM ASSEMBLY
5	1	D3696-1	ARM
6	1	D3799-1	OILITE BRONZE BUSHING
7	1	D3801-3	HAND RETRACTABLE SPRING PLUNGER
11	1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)



D3696-041 ARM ASSEMBLY

RELEASED
2010-05-17
JMD

D3696-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 1.68 lbs
- 8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING
- 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

D	REVISED ITEM 5 AS FOLLOWS: 'Ø 0.201 THRU CBORE Ø0.500 X 0.300 DP' NOW 2 PL (ZN C4-2 AND B4-2). REASON: ADDITION OF ALTERNATE ARMREST INSTALLATION D412-761-051 BASED ON FEEDBACK FROM END USERS AT HAI 2010	MB	10.05.06
C	REVISED ITEM 5 AS FOLLOWS: 'Ø 0.201 THRU CBORE Ø0.500 X 0.300 DP' WAS 2 PL (ZN C4-2). REASON: REDESIGNED ARMREST CUSHION BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.06.17
B	P/N D3799-1 WAS BNT-137 (ZN D6-1); P/N D3801-3 WAS PRT-12 (ZN C7-1). REASON: PURCHASED PARTS NOW PROCURED THROUGH D3799 AND D3801 SPEC CONTROL DRAWINGS; ADDED Ø 0.201 HOLE AND CBORE (ZN C6-2 AND D5-2). 17.50 WAS 19.50 (ZN B5-2). 1.000 WAS 0.990 +0.000/-0.010 (ZN C2-2); POCKETS REMOVED REASON: ELIMINATED FWD-AFT ARMREST ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	LA		
DRAWN	LA		
CHECKED	LA		
MFG. APPR.	LA		
APPROVED	LA		
DE APPR.	LA		
DATE	10.05.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

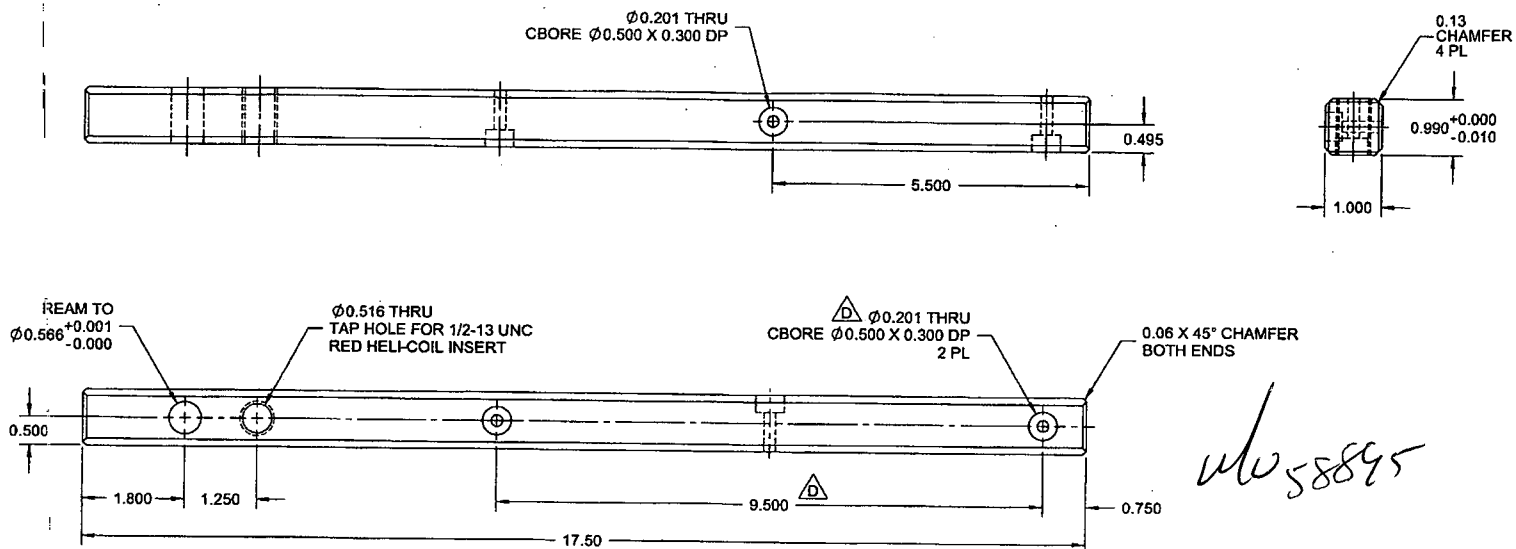
DRAWING NO.
D3696

REV. D
SHEET 1 OF 2

TITLE
ARM ASSEMBLY

SCALE
NTS

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D3696-1 ARM

W58895

RELEASED
2010-05-13
AW

D3696-1 NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11
REF. DART SPEC. M7075T6B
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.62 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3696	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARM ASSEMBLY	NTS
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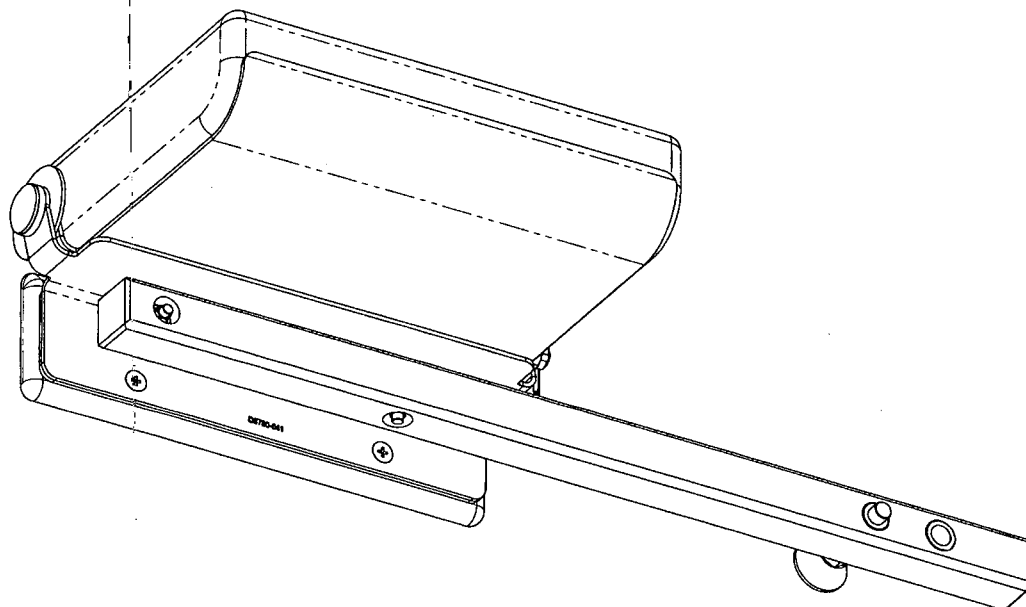
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4

3

2

1



D3780-041 ARMREST ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

ulb
58897

RELEASED
09/07/21 MB

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. I	
D3780		SHEET 1 OF 3	
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ARMREST ASSEMBLY		NTS	
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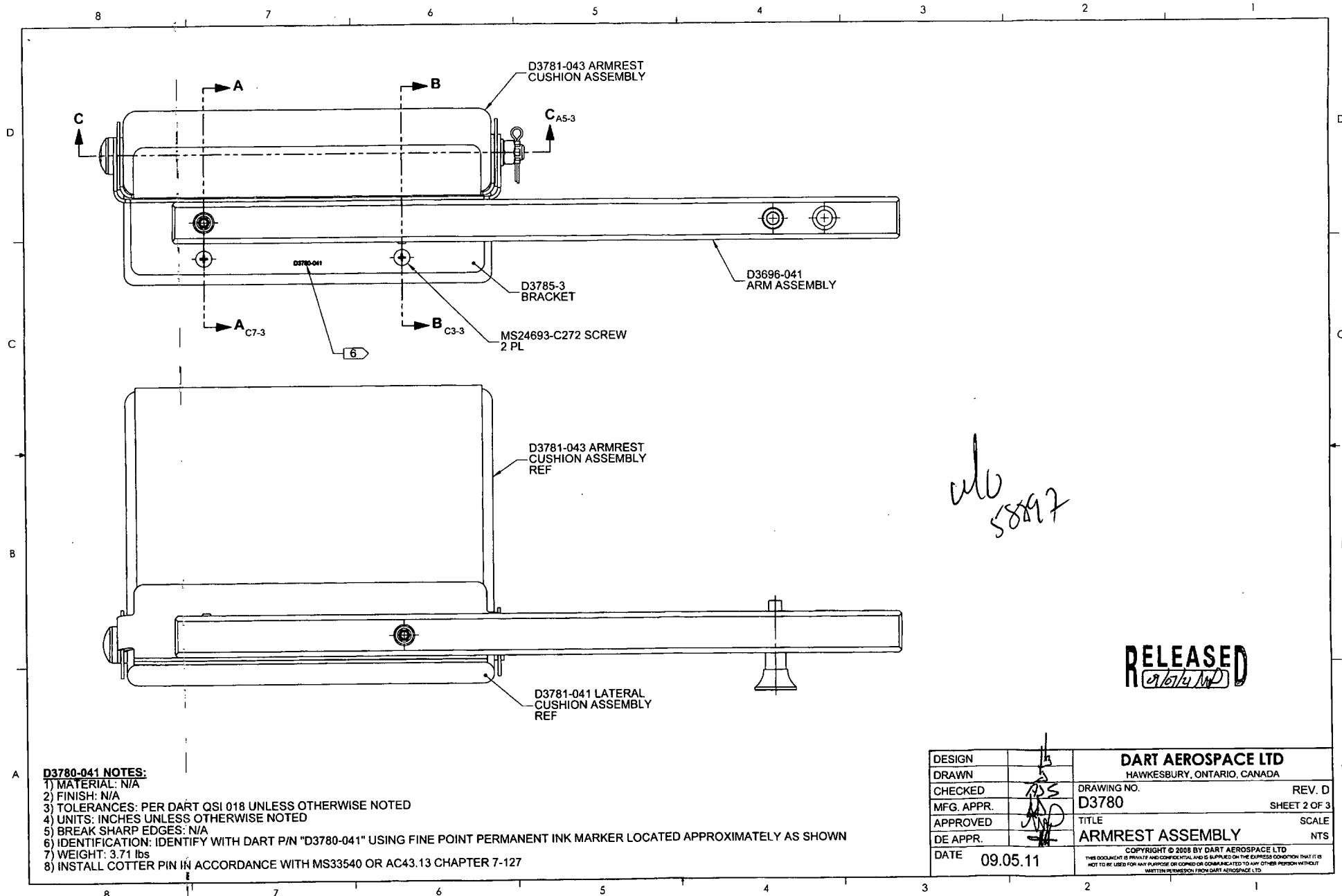
5

4

3

2

1



D3781-041 LATERAL
CUSHION ASSEMBLY
REF

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

MS24693-C277
SCREW

MS21042L3
NUT
AN960JD10L
WASHER

MS24693-C272
SCREW

MS24693-C277
SCREW

SECTION A-A C7-2

D3785-3
BRACKET
REF

AN960JD10L
WASHER

MS21042L3
NUT

D3781-041 LATERAL
CUSHION ASSEMBLY
REF

MS24693-C272
SCREW

SECTION B-B C8-2

AN970-6 WASHER
2 PL

NAS1149D0663J
WASHER

D3978-1 NUT (CASTELLATED), UNC
MS24665-302 COTTER PIN [B]

D3785-3 BRACKET
REF

D3977-1 BOLT (CARRIAGE), UNC

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

D3979-1 WASHER (SQUARE HOLE)

SECTION C-C D5-2
SCALE: 2X

WLO 58897

RELEASED
27/6/11

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